

Work Order ID 146949***146949***

Page 1

Tuesday, May 24, 2016 10:03:32 AM

Item ID: D412-761-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Instrument Panel

Stop ***NS2***

Start Date: 6/17/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML3 Date: MAY 26 2016

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-047 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 21 1607-23

DAS 27 9-89
AUG 26 2016

D

PC DAS 28 JUL 28 2016 9-89

DAS 27 9-89
AUG 26 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel

Start Date: 6/17/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/23/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-047								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
AUG 26 2016

AUG 26 2016

DAS
21
9-89

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B
13.01.15 as per ECN13-511 DD Verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A *AN3-4A* Bolt		Purchased	No			110	Each	157.0000	4	4			
DAS 27 9-89				<u>Location</u> ST350				<u>Loc Qty</u> 157		<u>Loc Code</u>			
				m134502				157					
D3705-11 *D3705-11* Main Panel		Manufactured	No			110	Each	0.0000	1	1			
D3705-7 *D3705-7* Main Panel		Manufactured	No			110	Each	1.0000	1	1			
DAS 27 9-89				<u>Location</u> ST052				<u>Loc Qty</u> 1		<u>Loc Code</u>			
				105314				1					
D3705-9 *D3705-9* Panel		Manufactured	No			110	Each	2.0000	1	1			
DAS 27 9-89				<u>Location</u> ST052				<u>Loc Qty</u> 2		<u>Loc Code</u>			
				139239				2					

** 4 X M134955 PC DAS 28 9-89

** 1 1 B146202 PC DAS 28 9-89

** 1 1 X B146199 PC DAS 28 9-89

** 1 1 X B146203 PC DAS 28 9-89

JUL 28 2016

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QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Page 2

Tuesday, May 24, 2016 10:03:32 AM

Work Order ID: 146949

146949

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 1.00

Required Qty: 1.00

D4758-1 Manufactured No

110 Each

31.0000

2 2

D4758-1

Blanking Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

ST123

31

146209

31

D4758-3 Manufactured No

110 Each

31.0000

3 3

D4758-3

Blanking Plate

DAS
27
9-89

Location

Loc Qty

Loc Code

ST123

31

146204

31

NAS1149D0332J Purchased No

110 Each

940.0000

10 10

NAS1149D0332.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

48

m134502

48

ST260a

600

m134738

600

ST264

286

m134502

286

D3705-041 Manufactured No

110 Each

0.0000

1 1

D3705-041

Instrument Paney Assy

DAS
27
9-89

**

DAS
6
9-89

AUG 25 2016
DAS 28 9-89

JUL 28 2016

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Picklist Print

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Page 3

Work Order ID: 146949

146949

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 1.00

Required Qty: 1.00

D3707-1
D3707-1

Mounting Lug

DAS
27
9-89

Manufactured No

110 Each

8.0000

2 2

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST052

8

134309

8

D3790-1
D3790-1

Indexing Block

Manufactured No

110 Each

3.0000

1 1

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST054

3

143646

3

D3867-1
D3867-1

Connector Plate

DAS
27
9-89

Manufactured No

110 Each

22.0000

1 1

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST055

22

143648

22

AN526C1032R6
AN526C1032R6

Screw

DAS
27
9-89

Purchased No

110 Each

340.0000

6 6

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST327

340

1892

340

AN743-12
AN743-12

Clip

DAS
27
9-89

Purchased No

110 Each

18.0000

2 2

**

PC DAS
28
9-89

Location

Loc Qty

Loc Code

ST330

18

M127124

18

JUL 28 2016

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Page 4

Work Order ID: 146949

146949

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 1.00

Required Qty: 1.00

MS21075L3 MS21075L3N Purchased No

110 Each

132.0000

MS21075L3

Nut Plate

**

⑥ X 129913 PC DAS 28 9-89

Location

Loc Qty

Loc Code

GA

32

m134257

32

ST298

100

m134782

100

110 Each

1,034.000

**

MS24693-C272

Purchased

No

MS24693-C272

Screw

**

PC DAS 28 9-89

Location

Loc Qty

Loc Code

OVER010

986

17137

467

17831

519

ST287

48

9370

48

110 Each

198.0000

**

MS27039-1-17

Purchased

No

MS27039-1-17

Screw (601.1954)

**

PC DAS 28 9-89

Location

Loc Qty

Loc Code

GA

185

120142

36

m127831

149

ST280

13

m127305

13

DAS
27
9-89

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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Picklist Print

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Page 5

Work Order ID: 146949

146949

Parent Item: D412-761-047

D412-761-047

Parent Item Name: Instrument Panel

Start Date: 6/17/2016

Required Date: 6/23/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-27

Purchased

No

110

Each

36.0000

1 1

MS27039-1-27

Screw

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST279

36

110606

36

MS21042L3

Purchased

No

110

Each

1,619.000

**

4 X M134943 PC DAS 28 9-89

MS21042L3

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

242

m133790

3

m134360

239

ST303

1277

m134039

12

m134360

65

m134634

600

m134754

600

MS21919-WDG8

Purchased

No

110

Each

58.0000

2 2

MS21919-WDG8

Clamp

**

PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST293

58

m128057

58

2

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER :																							

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(CONTINUED FROM PAGE 11)

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
				1					D3705-041	INSTRUMENT PANEL ASSEMBLY
				1					D3705-043	* INSTRUMENT PANEL WELDMENT
				1					D3335-1	* SPRING
				1					D3705-5	* ACCESS PANEL
				1					D3706-041	* LOCK BRACKET ASSEMBLY
				1					D3706-5	* PIN
				2					D3707-3	* MOUNTING LUG
				2					AN3-3A	* BOLT
				4					AN526C1032R6	* SCREW
				1					MS171498	* SPRING SLOTTED PIN
				4					MS24693-C272	* SCREW (OR MS24693-S272)
				2					NAS1149D0332J	* WASHER (OR AN960JD10L)
				1					NAS1149D0563J	* WASHER (OR AN960JD516)
				1					D3705-7	FACE PLATE (MINIMUM REQUIRED INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1					D3705-9	FACE PLATE (MINIMUM REQUIRED AND OPTIONAL INSTRUMENTS FOR 204, 205, 210, AND EAGLE SINGLE MODELS)
				1					D3705-11	FACE PLATE (FOR 212, 214, 412, MODELS)
				2					D3707-1	MOUNTING LUG
				1					D3790-1	INDEXING BLOCK
				1					D3867-1	CONNECTOR PLATE
				2					D4758-1	BLANKING PLATE
				3					D4758-3	BLANKING PLATE
				4					AN3-4A	BOLT
				6					AN526C1032R6	SCREW
				2					AN743-12	BRACKET
				6					AN960JD10L	WASHER
				6					MS21075L3	NUTPLATE (OR MS21073-3)
				4					MS24693-C272	SCREW (OR MS24693-S272)
				1					MS27039-1-17	SCREW
				1					MS27039-1-27	SCREW
				4					MS21042L3	NUT
				2					MS21919WDG8	CLAMP
				4					NAS1149D0332J	* WASHER (OR AN960JD10L)
					1	1			D3694-041	MOUNTING PLATE ASSEMBLY
					1	1			D3694-1	* KEYWAY
					1	1			D3694-3	* PROTECTIVE PLATE
					1	1			D3694-5	* MOUNTING PLATE
					1	1			AN526C1032R8	* SCREW
					4	4			MS21042L3	* NUT
					2	2			MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					1	1			MS24693-C271	* SCREW (OR MS24693-S271)
					4	4			MS24693-C273	* SCREW (OR MS24693-S273)
					5	5			NAS1149D0363J	* WASHER (OR AN960JD10)
					1	1			D3695-041	SLIDER ASSEMBLY
					1	1			D3695-1	* SLIDER
					1	1			D3695-3	* STOPPER
					1	1			MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
					4	4			MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
					4	4			MS24693-C276	* SCREW (OR MS24693-S276)
					1	1			D3801-1	* HAND RETRACTABLE SPRING PLUNGER

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE
(CONTINUED ON PAGE 13)

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Date: 16.05.26

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Setup Start *NS1*

Stop ***NS2***

Start Date: 6/17/2016 **Start Qty:** 1.00 ***1***

Required Date: 6/23/2016 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Approvals: _____ Process Plan: ML3 Date: MAY 26 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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